

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020566**Date Inspected:** 11-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: Seg3013K-061 [RS stiffener to Floor Beam (FB) 3184A, CJP weld at PP119-1500]. The welder is identified as 066361 and was observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

ZPMC personnel performing UT of K-Plate to Floor Beam weld joint at PP118. 3nos of locations are marked for repair.

Fit-up of DP3119A with DP3120A is in progress.

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OBG Seg 13CW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3015D-336 (Diaphragm to FB, CJP weld at PP124). The welder is identified as 045227 and was observed welding in the 2G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: Seg3015K-289 (Diaphragm to FB, CJP weld at PP122.5). The welder is identified as 067888 and was observed welding in the 2G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: Seg3015F-007 (Diaphragm to FB, CJP weld at PP123.5). The welder is identified as 201583 and was observed welding in the 2G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: Seg3015H-007 (Diaphragm to FB, CJP weld at PP123). The welder is identified as 066695 and was observed welding in the 2G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

OBG Seg 14W:

This QA Inspector observed ZPMC personnel performing fit-up of Anchor Plate (AP3017, 3018 and 3019) with Floor Beam, in progress.

Sub-assembly vertical shear plates, repair welding is in progress. Welding of Anchorage Plate with Bottom Panel started. See attached photo for further information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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